



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3573-3

Job Sheet 178835



Part No: D3573-3

Job Qty: 10 ea

Part Name: Adapter



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/8/18

Job Tracking No:

Due Date: 6/15/18

Created By: Marie Lajeunesse

Type: **SOLD**

Description:

Note: DWG REV A IPP Rev:A New Issue 07-01-29 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	6/15/18	6/15/18	0.00	0.00	Start Up Machining-2		Kt 2018-06-26
100	Bandsaw	10 pcs	6/15/18	6/15/18	0.00	0.83	Bandsaw1		Kt 2018-06-26
110	CNC Vertical Machining	10 pcs	6/15/18	6/15/18	0.29	10.87	HAAS1-4		Kt 2018-06-26
120	QC	10 pcs	6/15/18	6/15/18	0.00	0.00	QC2 Machining-2		Kt 2018-06-26
130	QC	10 pcs	6/15/18	6/15/18	0.00	0.00	QC8 Machining-2		A 18-06-26
140	HandFinish	10 pcs	6/15/18	6/15/18	0.00	1.72	HandFinish1		BEB 18-06-26
150	Powdercoat	10 pcs	6/15/18	6/15/18	0.00	0.50	Powdercoat3		BR 18-06-26
160	QC	10 pcs	6/15/18	6/15/18	0.00	0.00	QC3		38
170	Packaging	10 pcs	6/15/18	6/15/18	0.00	0.00	Packaging3-1		9-88
180	QC21-SA	10 Ea	6/15/18	6/15/18	0.00	0.00	QC21		JUN 27 2018

Part Op 100 - Cut blank 3.500" long

Descriptions: 110 - Machine as per Folio FA673 and Dwg D3573

150 - START TIME: 2:35

170 - LOCATION : GA

011: 500° FINISH: 8:05

M136378

DAS
21
9-88

JUN 27 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.500X02.500	6061-T6 Bar .500 X 2.50	2.9200 ft (.292 ea)	90-Start up Operation	5035403

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.500X02.500	3	24	0

Part Specifications

Specifications could not be found



Container No: S084085



Part: D3573-3

Job No: 178835

Serial No/Batch: S084085

Revision:

Inspector:

Exp Date:

Instructions:

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

8:04 AM Dart.lajeunesse.marie

Date: 06/26/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

DART AEROSPACE LTD		Work Order: 178831
Description: Adapter		Part Number: D3573-3
Inspection Dwg: D3573	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.31	+/-0.030	3.312	✓		Vernier	
2.69	+/-0.030	2.687	✓		high gage	
2.31	+/-0.030	2.307	✓		Vernier	
1.600	+/-0.005	1.597	✓		Vernier	
0.36	+/-0.030	.357	✓		Vernier	
1.19	+/-0.030	1.189	✓		high gage	
2.38	+/-0.030	2.376	✓		Vernier	
1.420	+/-0.010	1.418	✓		Vernier	
0.48	+/-0.030	.475	✓		Vernier	
R0.63	+/-0.030	R.630	✓		Gaborit	
R0.13	+/-0.030	R.130	✓		Gaborit	
R0.02	+/-0.030	R.020	✓		Gaborit	
Ø0.209	+0.005/-0.001	.210 Ø	✓		Pin gage	
Ø0.266	+0.006/-0.001	.267 Ø	✓		Pin gage	
0.390	+0.010/-0.000	.391	✓		micrometer	
Ø0.675 x 0.190	+/-0.010	.673 x .189	✓		Vernier	
Ø0.500 x 0.310	+/-0.010	.499 x .309	✓		Vernier	

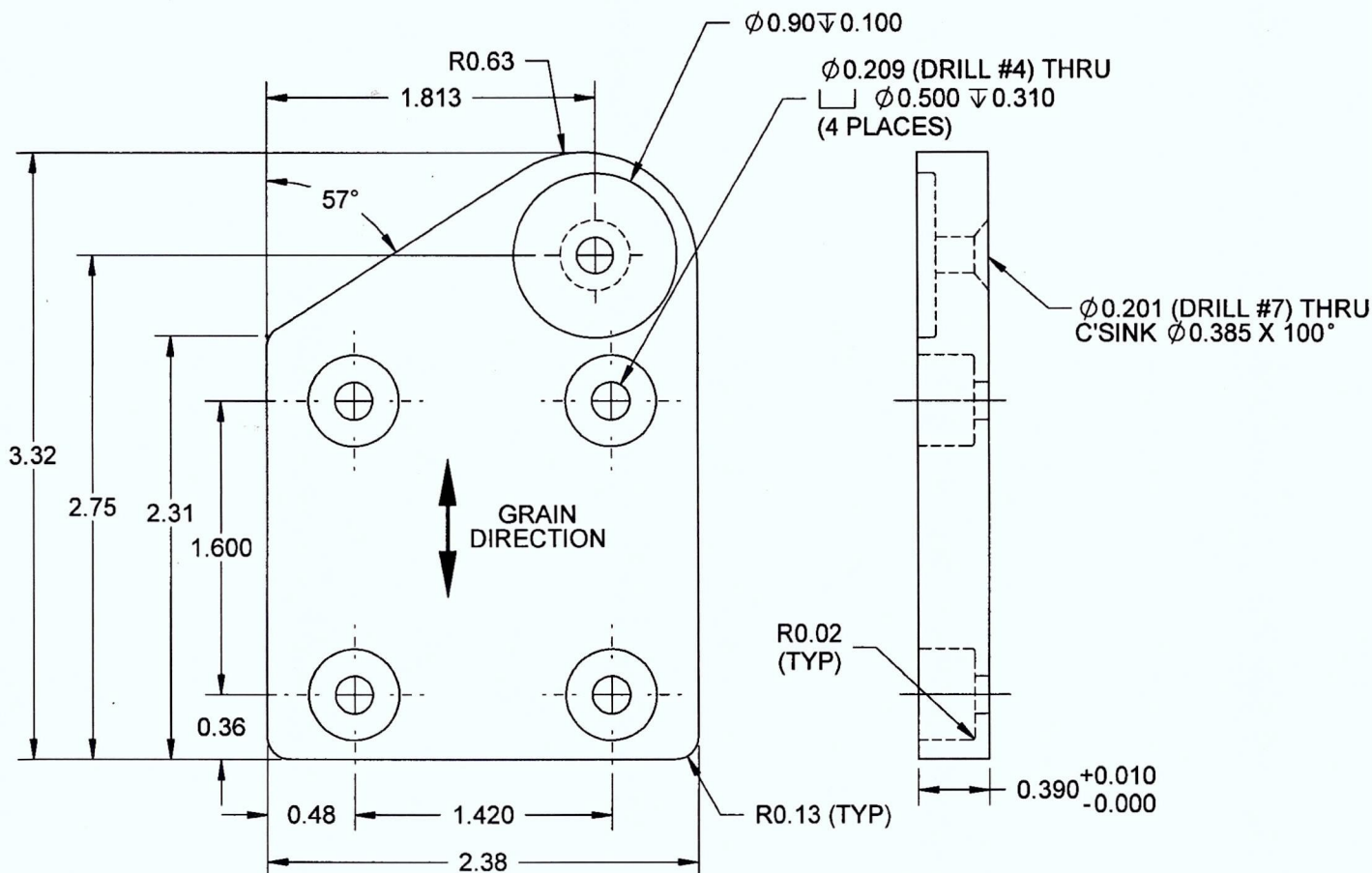
Measured by: M.M.	Audited by: B.S.	Prototype Approval:	N/A
Date: 2018/06/25	Date: 18-06-26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.04	New Issue	KJ/JLM	[Signature]



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573	REV. A SHEET 4 OF 4
DATE 07.02.19	TITLE ADAPTER		SCALE 1:1

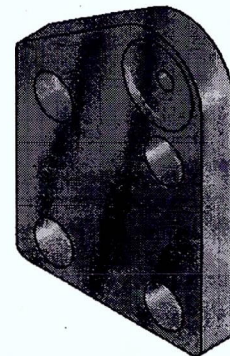
RELEASED
07.04.02 *[Signature]*



D3573-7 ADAPTER (SHOWN)
D3573-8 ADAPTER (OPPOSITE)

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-7/-8" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



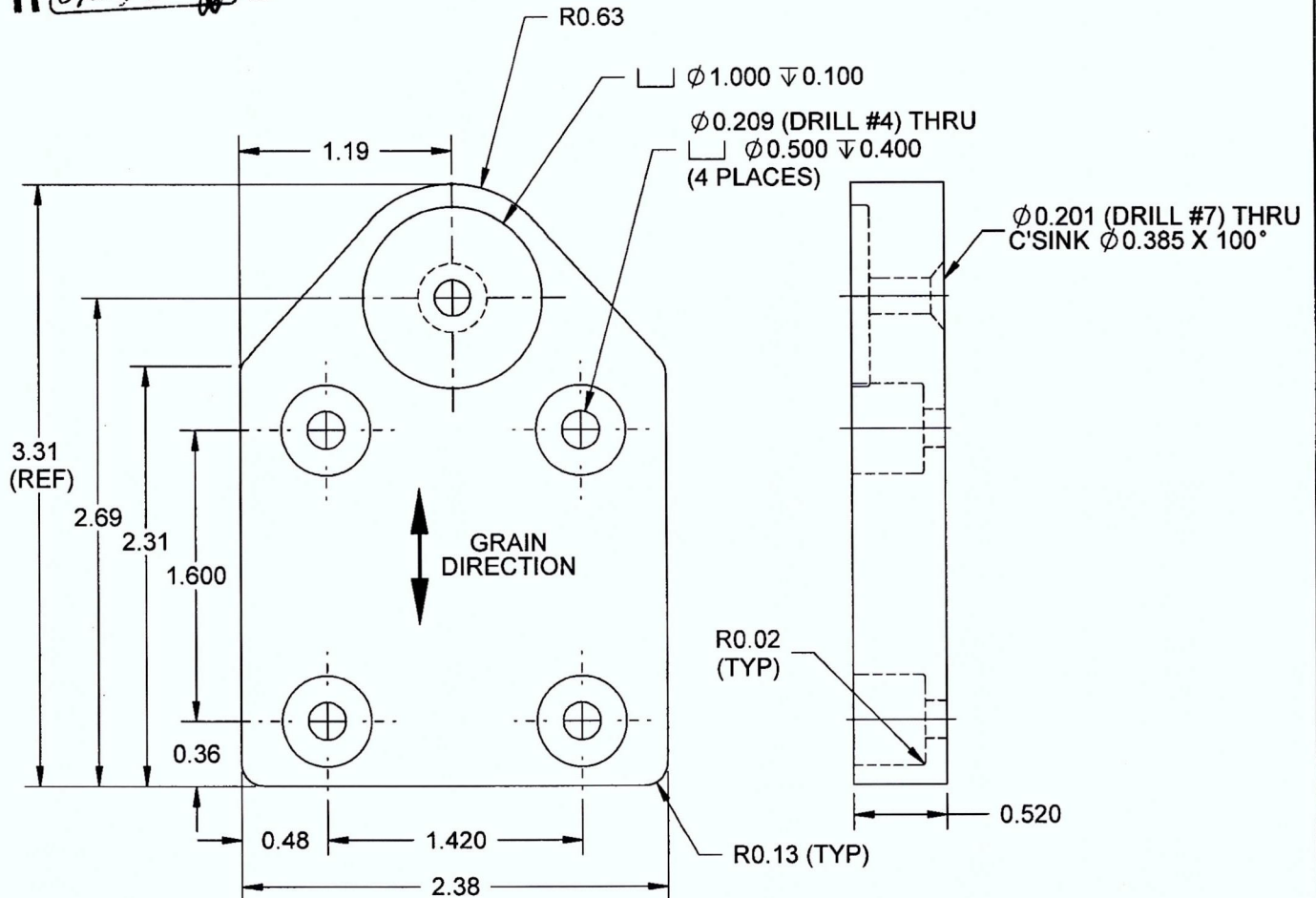
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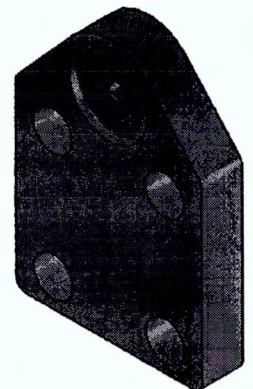
T5 op2 - [Signature]
-004

DART

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573	REV. A SHEET 1 OF 4
DATE 07.02.19	TITLE ADAPTER		SCALE 1:1
REV A	DATE 07.02.19	DESCRIPTION NEW ISSUE	

RELEASED
07.03.22**D3573-1 ADAPTER****NOTES:**

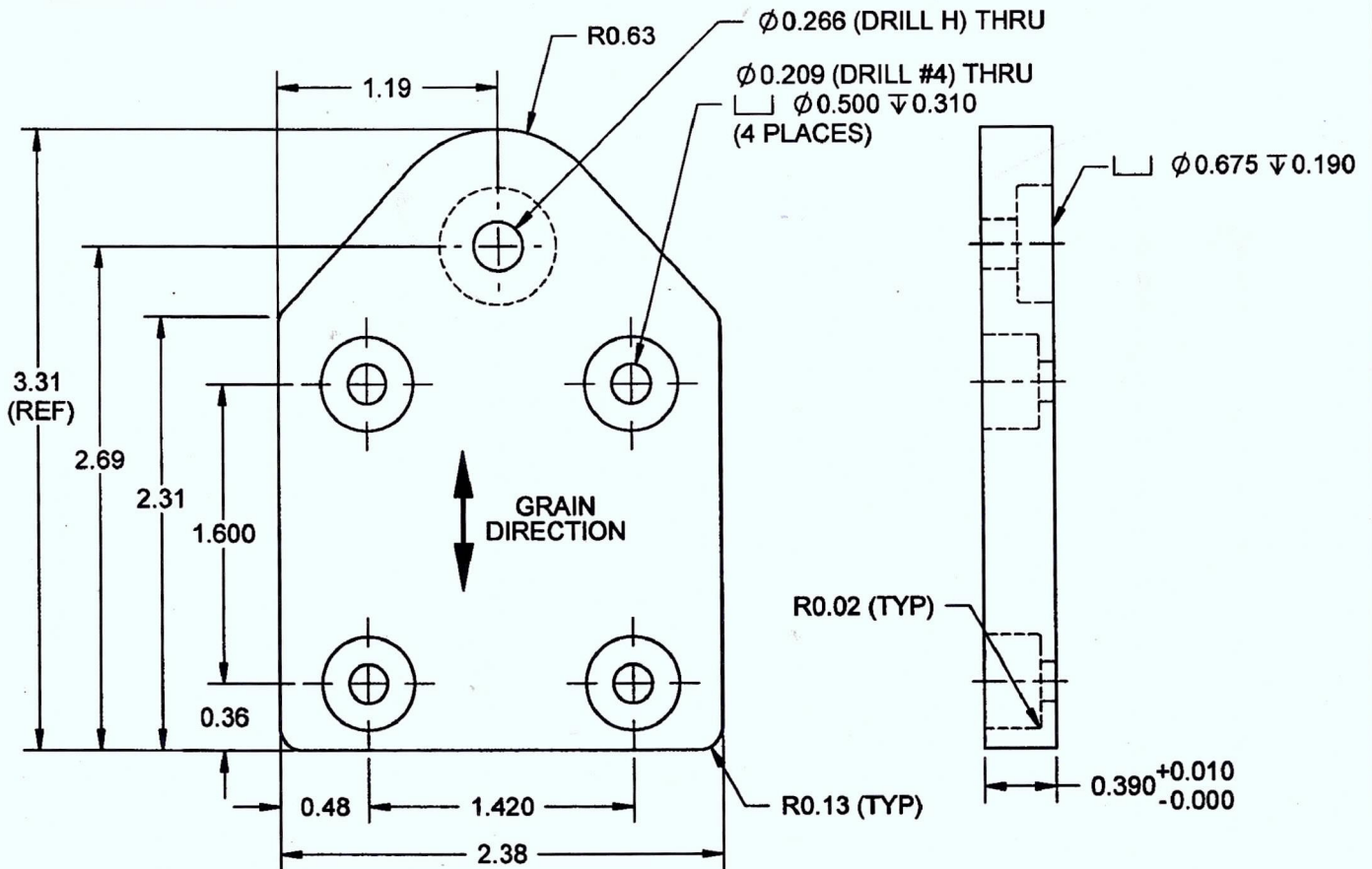
- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
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- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DATE 07.02.19		TITLE ADAPTER	SCALE 1:1

RELEASED
07.04.02**D3573-3 ADAPTER****NOTES:**

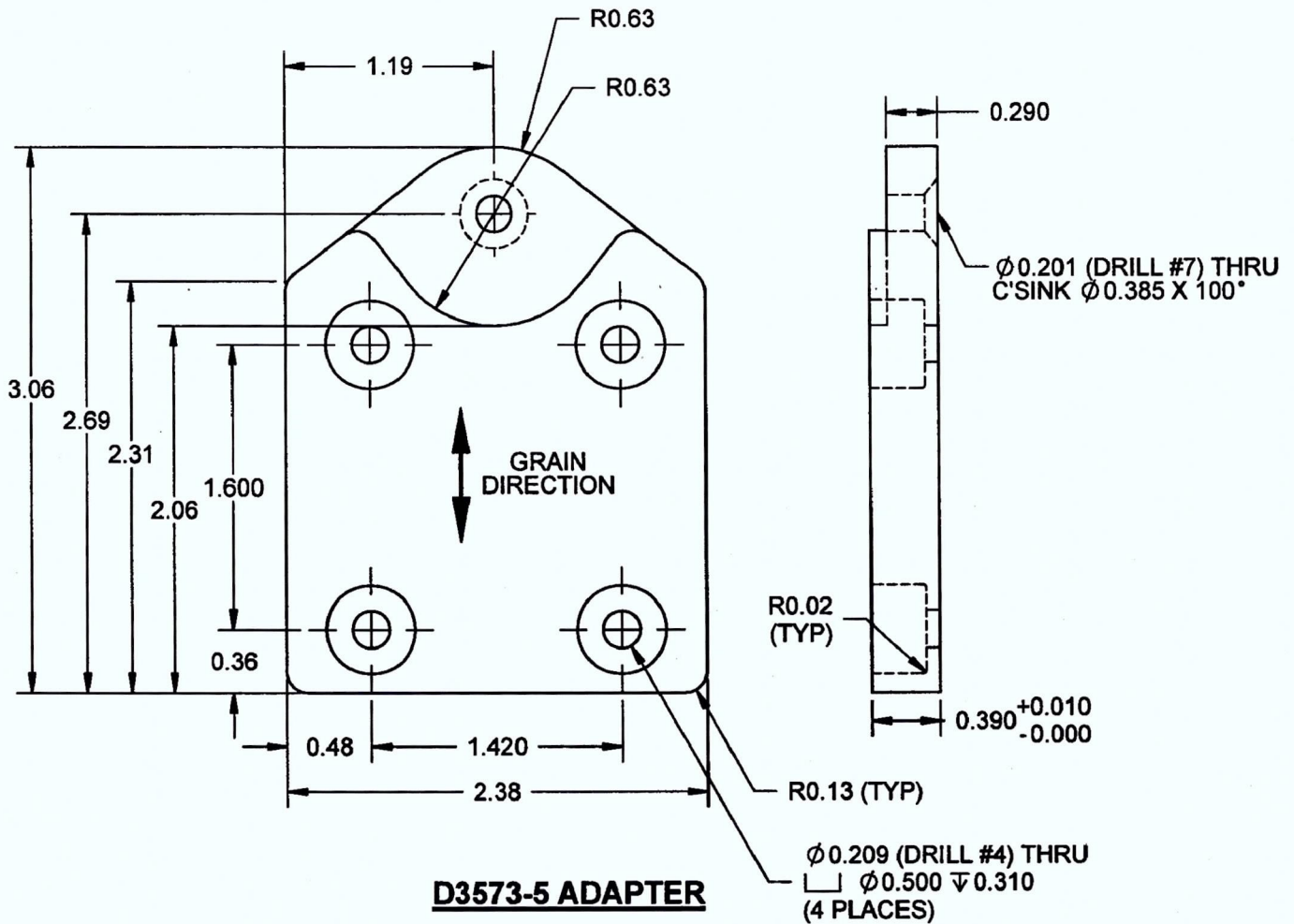
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DATE 07.02.19		TITLE ADAPTER	SCALE 1:1

RELEASED
07.04.02**NOTES:**

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(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
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- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-5" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
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